

Date: Tuesday, 4/17/2007 3:09:05 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP (CASTING DETAIL)		
Job Number	: 31940		Part Number	: D25761		
Estimate Number	: 11088		Drawing Number	: D2576 REV E1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	4/17/2007	S.O. No.	: N/A		Drawing Revision	E1
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 4/30/2007		
Previous Run	: 29514		Qty:	100	Um:	Each
Written By	:		Comment	:		
Checked & Approved By	:		Est Rev: A	New Issue	05-11-29	JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <u>3574</u> <i>CL 07/04/18</i> <i>100</i> Ship D2576 mould to vendor Cast per D2576-1 Pattern Material Release Note Required		
2.0	D25761P	Step (Casting Detail)
Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) STEP		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure D2576 mould is returned with the ordered parts Ensure release note is attached		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK <i>CL 07/05/02 106</i> <i>QSP09</i>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(106)

Comment: FINAL INSPECTION/W/O RELEASE

F 07/05/02

Job Completion



U 07/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



copy issued
date

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>HE</i>	DRAWING NO. D2576	REV. E SHEET 1 OF 1
DATE 99.09.07		TITLE STEP	SCALE 1:4

RELEASED
99.09.08 DS

99.08.28
99.08.28

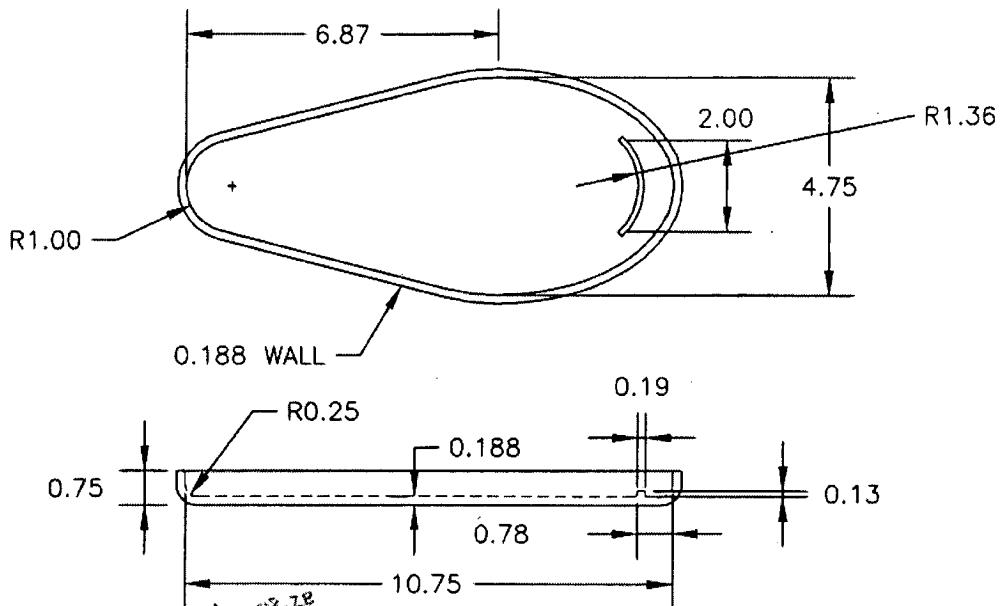
CASTING DETAIL (D2576-1) (P₀₀ 08.28)

MATERIAL: CAST ALUMINUM ALLOY A-535.2

BREAK SHARP EDGES 0.025 TO 0.050

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES



MACHINING DETAIL (D2576-3) (P₀₀ 08.28)

D 0.250 X 0.65 SLOT
(4 PLACES)
IN APPROX. LOCATION SHOWN

0.063 POCKET (LEAVE 0.125)

0.250 X 1.28 SLOT **D**

IT IS ACCEPTABLE TO OPEN
THIS HOLE 0.125 IN EITHER
DIRECTION AS SHOWN
FOR WELDING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31940

ALPINE NON-FERROUS FOUNDRY
8657-132ND STREET
SURREY, B.C. V3W 4P1

WORK ORDER

Tel: (604) 596-8080 Fax: (604) 596-8045

Sold To: **DART AEROSPACE**
1270 ABERDEEN STREET
HAWKESBURY, ONT K6A 1K7
CANADA

Ship To: **DART AEROSPACE**

Order Date	Purchase Order#	Due Date	Ship Via		Page
18-Apr-2007	PO00003574	03-May-2007	FEDEX		1
Item#	Item Code	Description	Material	Ordered	B/O
1	DART D2576	D2576 STEP CSTG		100	
2					106

Comments

Castings&Patterns are property of Alpine until paid in full

Apr. 30/07

44A66